

Work Order ID 74766-2

October 6, 2011 9:16:51 AM

74766

U/R

Page 1

Item ID: D2940-1

Revision ID: U/R

Item Name: Support

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/06/11 Start Qty: 20.00

20

Required Date: 11/15/11 Req'd Qty: 20.00

20

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: M.C.S

Date: 11/16/11 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2940	C								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								
HAAS 1		0.00							
HAAS CNC vertical machine #1	Memo 1-Machine as per Folio FA079 2-Deburr								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								
120		0.00							
120	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

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Page 2

Item ID: D2940-1

Revision ID: U/R

Item Name: Support

Start Date: 10/06/11

Start Qty: 20.00

Required Date: 11/15/11

Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

HandFXtube

Hand Finishing Crosstubes

Memo

Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

0.00

0.00

ET/2

11-11-14

140

140

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

W

11-11-15

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: *X-tube*

Memo

assy

0.00

0.00

W

11-11-15

Work Order ID 74766

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74766

Page 3

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Item Name: Support

Start Date: 10/06/11

Start Qty: 20.00

Required Date: 11/15/11

Req'd Qty: 20.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

11/11/15

R11-11-15
(15)

Picklist Print

October 6, 2011 9:16:55 AM

Page 1

Work Order ID: 74766

Parent Item: D2940-1

Parent Item Name: Support

74766

D2940-1

Start Date: 10/06/11

Required Date: 11/15/11

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C 02.11.26 Reformat; Added P/OKJ
 IPP Rev:D Added priming as per Rev B 07-04-30 JLM
 IPP E 08.03.19 Re-format Ec verified by DD
 IPP Rev:F 08-10-22 add qc14 DD verified by:EC
 11.08.04 as per dwg rev.C DD ver:EC

IPP Rev:G

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	14.0000	0.5	10.52632			

DSK081

D2940-1 TURNING DETAIL

**

Location

Loc Qty

Loc Code

MAT

4

69717

4

MAT050

10

72867

10

1/2 10/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74766
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.155	.155	.155	.155	.155
AD	3.510	3.530		3.522	3.522	3.524	3.524	3.524
AE	1.633	1.673		1.660	1.663	1.664	1.664	1.664
AF	1.493	1.513		1.503	1.503	1.503	1.503	1.503
AG	0.040	0.060		.050	.05	.05	.05	.05
AH	0.188	0.193		.189	.189	.189	.189	.189
AI	0.140	0.160		.150	.150	.150	.150	.150
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.153	.153	.153	.153	.153
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.160	.160	.160	.160	.160
AQ	0.053	0.073		.06	.06	.06	.06	.06
AR	101.64	105.64		✓	✓	✓	✓	✓
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.130	4.130	4.130	4.130	4.130
AV								
AW								
Accept/Reject								

Measured by: <i>[Signature]</i>	Date: 11/10/11
Audited by: <i>[Signature]</i>	Date: 11/10/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

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☒ First Article ☐ Prototype

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AD	3.510	3.530		3.524	3.524	3.524	3.524	3.524
AE	1.633	1.673		1.664	1.663	1.660	1.663	1.660
AF	1.493	1.513		1.503	1.502	1.506	1.502	1.506
AG	0.040	0.060		.05	.05	.05	.05	.05
AH	0.188	0.193		.189	.189	.189	.189	.189
AI	0.140	0.160		.150	.150	.150	.150	.150
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AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.153	.150	.148	.150	.148
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.160	.160	.160	.160	.160
AQ	0.053	0.073		.06	.06	.06	.06	.06
AR	101.64	105.64		✓	✓	✓	✓	✓
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.150	4.170	4.170	4.170	4.170
AV								
AW								
Accept/Reject								

Measured by: <i>BC</i>	Date: 11/1/14
Audited by: <i>ML</i>	Date: 11/11/14
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

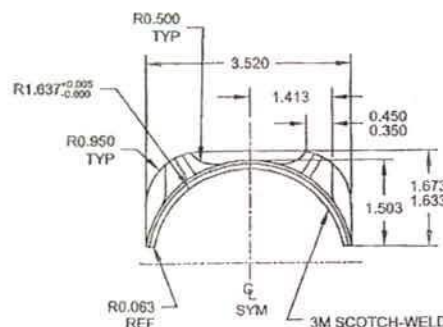
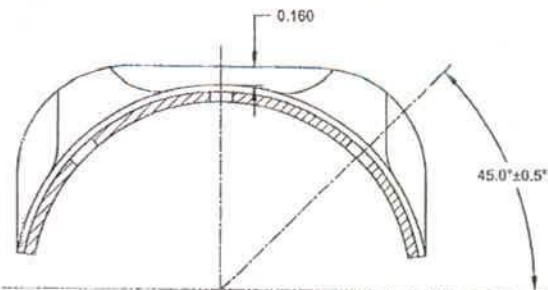
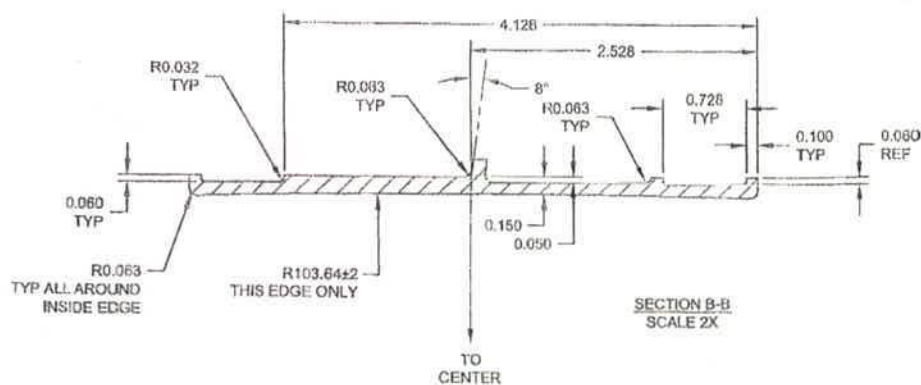
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AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.01	.01	.01	.01	.01
AM	0.140	0.160		.153	.153	.153	.153	.153
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.160	.160	.155	.160	.160
AQ	0.053	0.073		.06	.06	.06	.06	.06
AR	101.64	105.64		✓	✓	✓	✓	✓
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
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AV								
AW								
Accept/Reject								

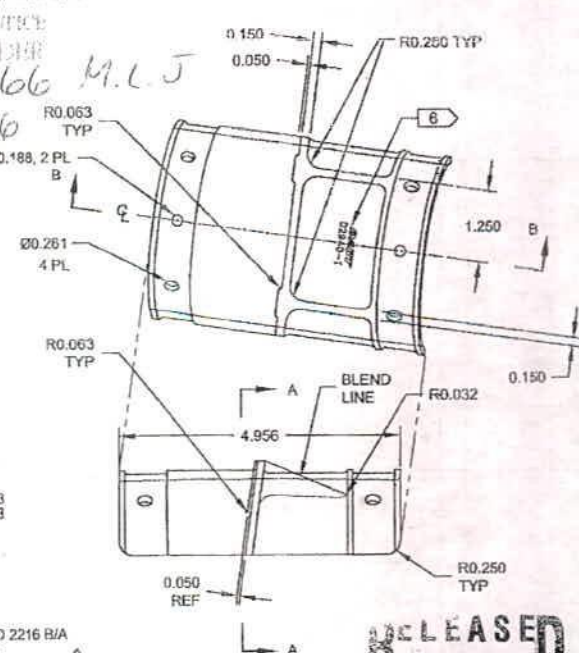
Measured by: <i>SK</i>	Date: 11/11/12
Audited by: <i>CMX</i>	Date: 11/11/14
Prototype Approval:	Date:

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3M SCOTCH-WELD 2216 B/A
EPOXY ADHESIVE
0.03" - 0.05" THICK

B B



RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.92 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2940-1 SUPPORT

C	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION	CP	11.07.15
B	UPDATE PER NCR 842, PRIME B/SIDE	PH	87.03.13
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2940 REV. C SHEET 1 OF 1 SCALE: NTS COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR REPRODUCED IN ANY FORM WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DRAWN	DP		
CHECKED	ASS		
MFG. APPR.	DP		
APPROVED	DP		
DE APPR.	DP	DATE 11.07.15	

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